

Date: Wednesday, 12/7/2005 12:45:28 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WHEEL SHAFT R22/R44
Job Number : 25167	
Estimate Number : 11267	
P.O. Number : N/A	Part Number : D33571
This Issue : 12/7/2005 S.O. No. : N/A	Drawing Number : D3357 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/10/2006
Checked & Approved By : <u>SEE COMMENT BELOW</u>	Qty: 22 Um: Each
Comment : Est Rev:A 05.09.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174R1000	17-4PH SS ROUND BAR 1.00
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Comment: Qty.: 0.4809 f(s)/Unit Total: 9.6180 f(s)
 17-4PH SS ROUND BAR 1.00
 (M174R0100)
 Batch: M19430

ML 06/01/27

22

PTO

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA503 and Dwg D3357

2-Deburr

ML 06/01/27

22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/01/27

22

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Mill as per Dwg D3357

ML 06/01/27

22

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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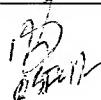
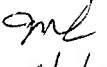

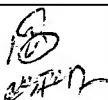

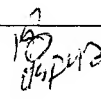
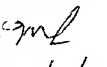
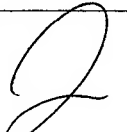
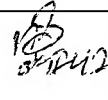

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/01/27

22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 06/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/26	2	1. one piece scrap the final dim too small.		destroy and replace	 06/01/27	 06-01-31		 06-01-31
		2. one piece scrap. the thread was wrong						
06/01/27	2	3. one piece scrap. wrong thread too deep		destroy and replace	 06/01/27	 06-01-31		 06-01-31

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 12:45:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL SHAFT R22/R44

Job Number: 25167

Part Number: D33571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06/01/31 22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 420

C206/01/31 22

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

19 06/02/01

Job Completion



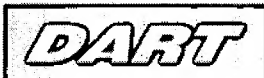
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

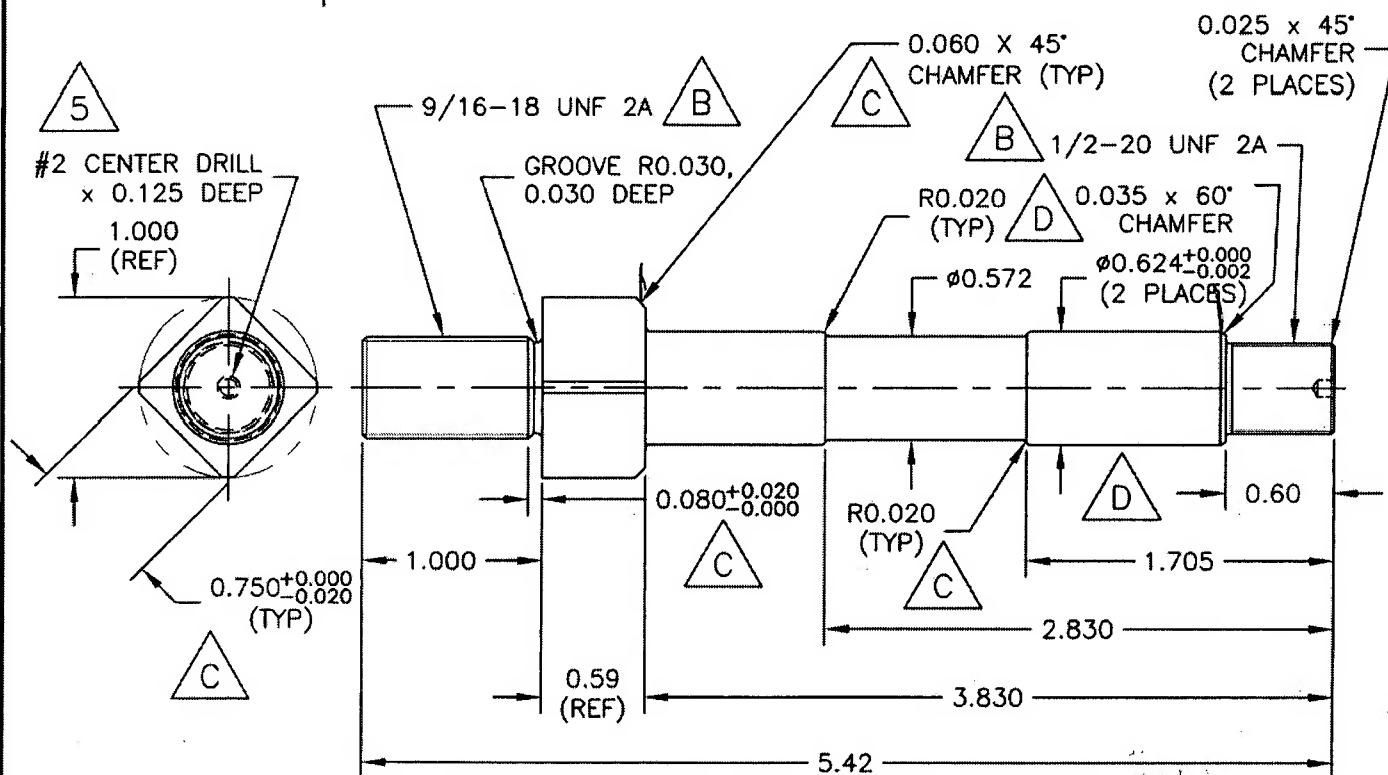
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3357	REV. D SHEET 1 OF 3
DATE 05.12.02		TITLE SHAFTS	SCALE 1:1
A	04.12.13	NEW ISSUE	
B	05.05.27	ADD THREAD SPEC & 0.063; 17-4 PH ROUND WAS 303 HEX SS	
C	05.07.21	0.750 WAS 0.625; 0.100 WAS 0.063	
D	05.12.02	Ø0.624 WAS Ø0.623; 0.60 WAS 0.71	

RELEASED

05/12/02



D3357-1 R22/R44 WHEEL SHAFT

NOTES:

- 1) MATERIAL: 17-4 PH ROUND BAR STAINLESS STEEL CONDITION H900 (REF. DART SPEC. M17-4-R1.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) CENTER DRILL AS REQUIRED

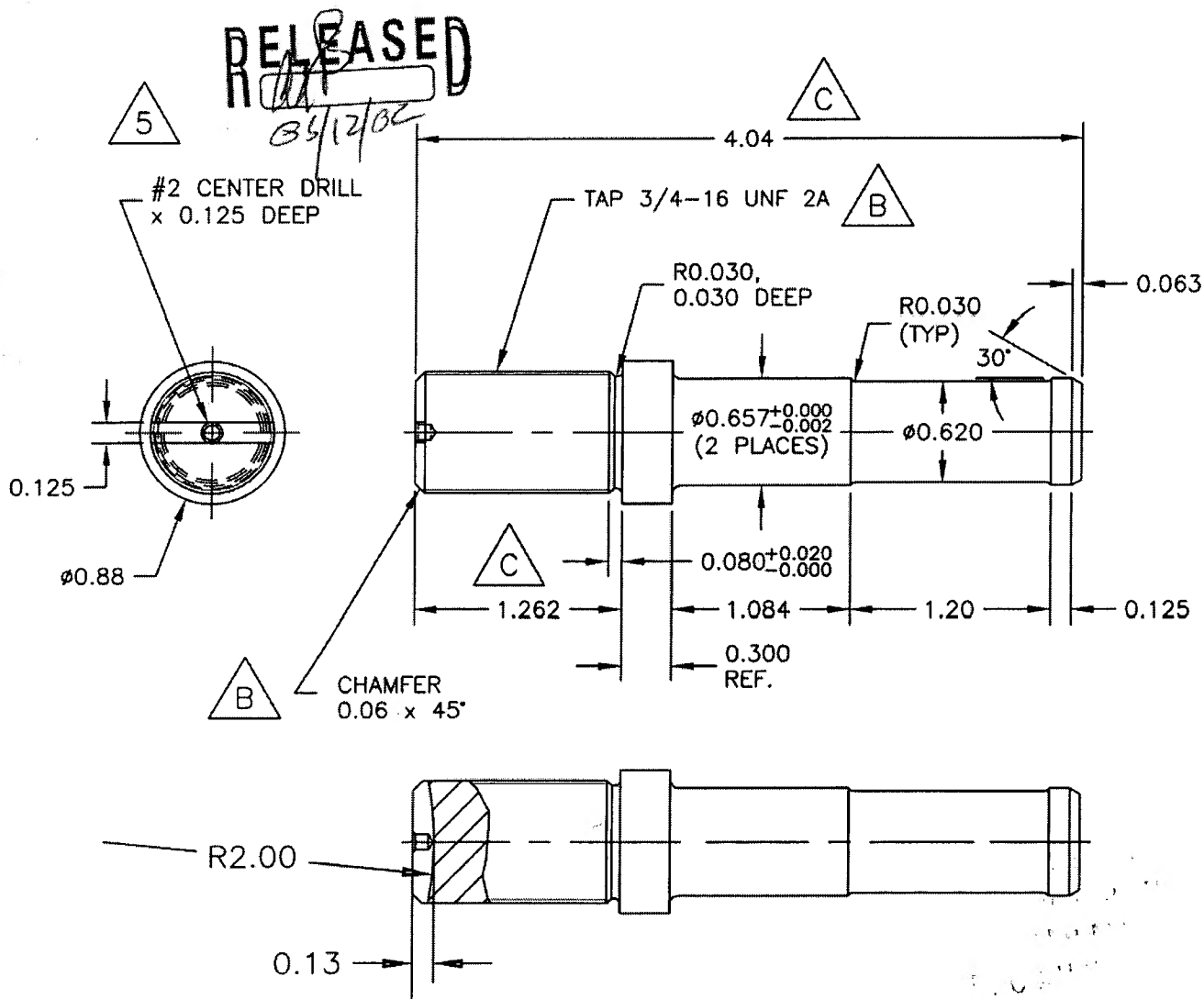
25167
B

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CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3357	REV. D SHEET 2 OF 3
DATE 05.12.02		TITLE SHAFTS	SCALE 1:1



D3357-3 R22 LOCK SHAFT

NOTES:

- 1) MATERIAL: 17-4 PH ROUND BAR STAINLESS STEEL CONDITION H900
(REF. DART SPEC. M17-4-R1.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) CENTER DRILL AS REQUIRED

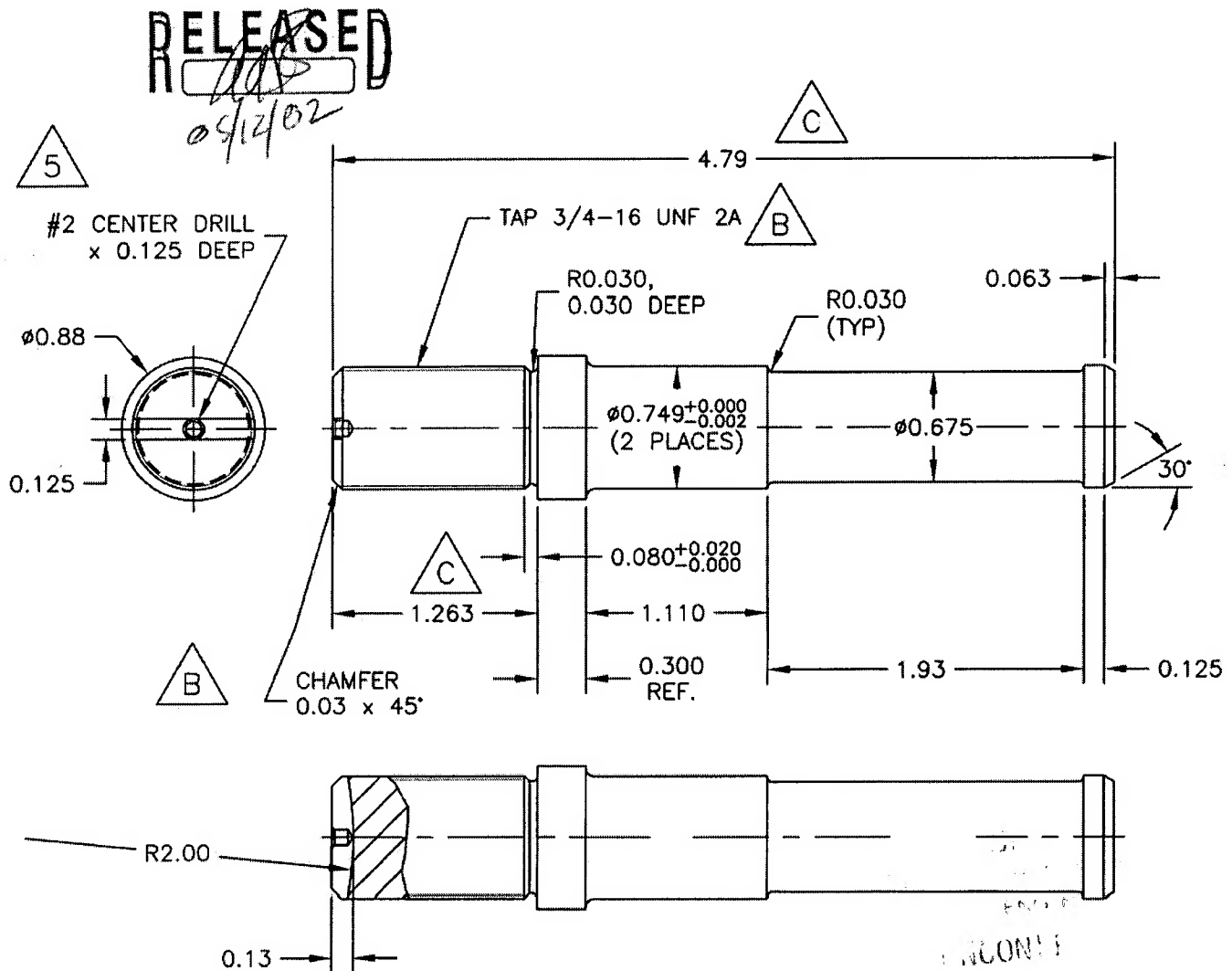
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3357	REV. D SHEET 3 OF 3
DATE 05.12.02		TITLE SHAFTS	SCALE 1:1



D3357-5 R44 LOCK SHAFT

NOTES:

- 1) MATERIAL: 17-4 PH ROUND BAR STAINLESS STEEL CONDITION H900
(REF. DART SPEC. M17-4-R1.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) CENTER DRILL AS REQUIRED

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